

Date: Wednesday, 06/09/2006 11:05:06 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GPS RECEIVER HOUSING
Job Number : 28418	
Estimate Number : 12492	
P.O. Number : N/A	Part Number : D35143
This Issue : 06/09/2006 S.O. No. : N/A	Drawing Number : UNDER REVIEW <i>E 06.09.05</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : N/A
Previous Run : N/A	Material : N/A
Written By : <i>EE</i>	Due Date : 13/09/2006 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 06-07-26 JLM	

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.4812 sf(s)/Unit Total : 0.4812 sf(s)
 6061-T6 .040 Sheet
 (M6061T6S040)
 Batch: *M19380*

ml 06 09 07

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3514
 Dwg Rev: *Pre1*
 Prog Rev: *Pre1*

ml 06 09 07

①

Ensure Grain Direction is correct**

2-Deburr if necessary

ml 06 09 07

①

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE*ml 06 09 07*

①

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK*SA 06 09 07*

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 02/09/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/09/2006 11:05:06 AM
User: Linda Lacelle

Process Sheet

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Drawing Name: GPS RECEIVER HOUSING

Job Number: 28418

Part Number: D35143

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Countersink as per Dwg D3514

SB 06/09/14 ①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE
Form as per Dwg D3514

SB 06/09/14 ①

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06-09-14 ①

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

9.m 06-09-18 ①

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/15 ①

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 37448

SB 06/09/19 ①

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

SB 06/09/19 ①

Job Completion



W 06/09/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

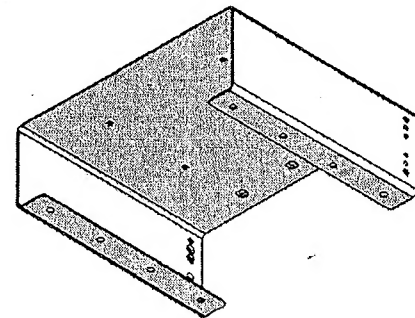
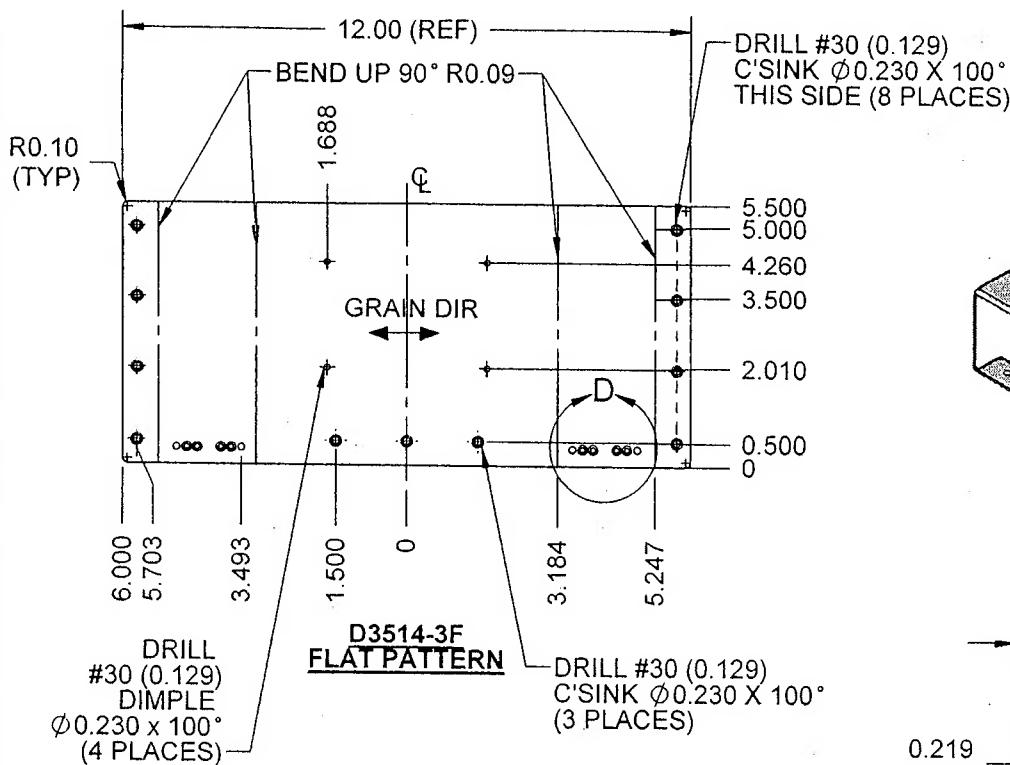
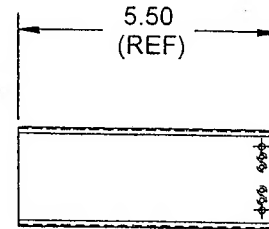
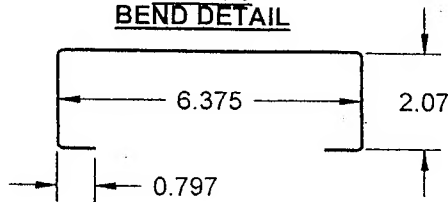
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3514	REV. A
DATE 06.05.03		TITLE GPS RECEIVER HOUSING	SHEET 4 OF 7 SCALE 1:4

UNDER REVIEW

06.08.22 CB.

prototype

D3514-3 BEND DETAIL

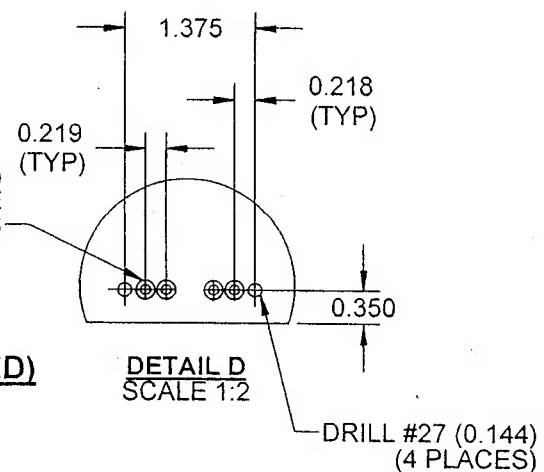


D3514-3F FLAT PATTERN

DRILL #30 (0.129)
C'SINK Ø0.230 X 100°
(3 PLACES)

DRILL #40 (0.098)
C'SINK Ø0.182 X 100° THIS SIDE
(8 PLACES) FOR RIVETS

D3514-3 BOX TOP (TOP MOUNTED)



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.040 SHEET (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) SKETCH IS SYMMETRICAL ABOUT ϕ
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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